

Date: Tuesday, 03/02/2009 11:00:08 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services*	Drawing Name	: DRIVE SHAFT TUNNEL
Job Number	: 45449		
Estimate Number	: 13044		
P.O. Number	:	Part Number	: D3648041
This Issue	: 03/02/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3648 REV.B
First Issue	: //	Project Number	: N/A
Previous Run	: 45286	Drawing Revision	: B
Written By	:	Material	:
Checked & Approved By	: <u>JLD 09.02.03</u>	Due Date	: 10/02/2009
Comment	: Est Rev:A New Issue 07-10-03 EC verified by: DD	Qty:	2 Um: Each
	: Est Rev:B Ecn 1113P 08-01-22 DD verified by:EC		
	: Est Rev:C ECN1162 08-04-02 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D3649041	Tunnel Bottom Panel Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 TUNNEL ASSEMBLY, BOTTOM PANEL
 batch: B 44940

FF 09/02/04

(2)

3.0	D3650041	Tunnel Top Panel Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 WELDMENT ASSEMBLY, TOP PANEL
 batch: B 45448

FF 09/02/04

(2)

4.0	D3651041	Aft Base Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 AFT BASE ASSEMBLY
 batch: 45678

FF 09/02/26

(2)

5.0	AN3C3A	Bolt
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Comment: Qty.: 40.0000 Each(s)/Unit Total: 80.0000 Each(s)
 Bolt
 batch: M 110915

FF 09/02/04

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/02/2009 11:00:08 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DRIVE SHAFT TUNNEL

Job Number: 45449

Part Number: D3648041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

AN960C10

WASHER



Comment: Qty.: 40.0000 EACH(s)/Unit Total: 80.0000 EACH(s)

WASHER

batch: M109165

FF 09/02/04

(2)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per dwg D3648

2- Seal mating surface and all gaps as per dwg D3648 with

Proseal 700 fire wall sealant

batch: M110624

FF 09/02/04

Polish Tunnel? → M. 204/28/04

(2)

(2)

FF 09/02/25

(2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S. 09/03/18

(2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: PPP 46559

S. 09/03/18

(2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/19

Job Completion



MF
09-03-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

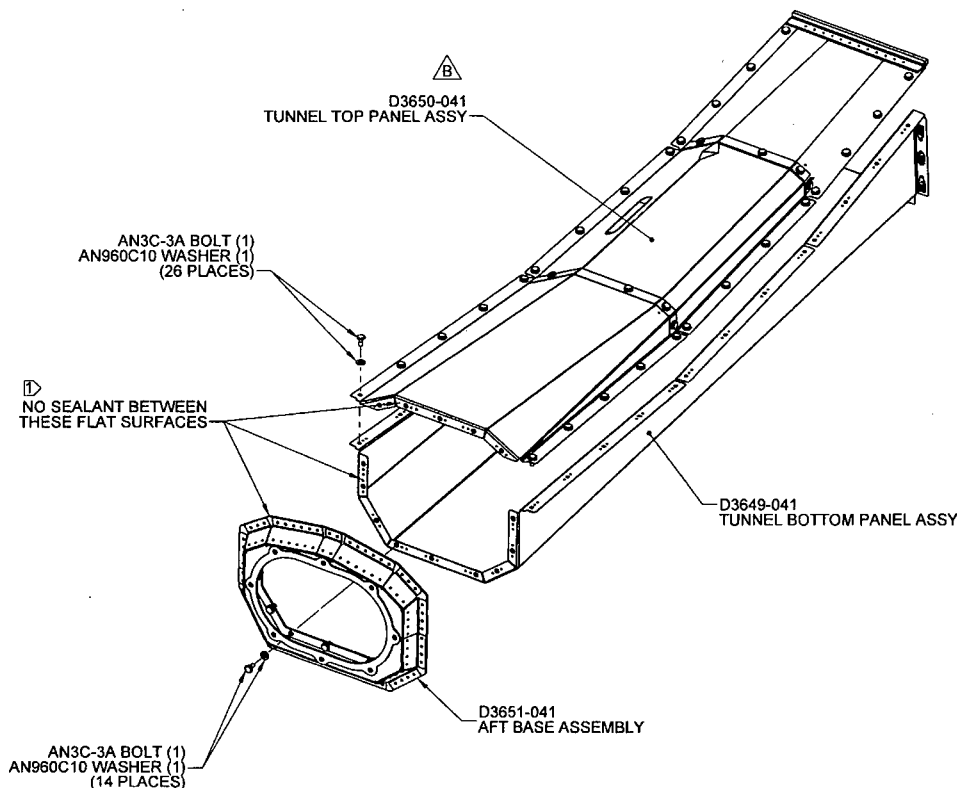
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3648-041	DRIVE SHAFT TUNNEL ASSEMBLY
1	D3649-041	TUNNEL BOTTOM PANEL ASSEMBLY
1	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3651-041	AFT BASE ASSEMBLY
40	AN3C-3A	BOLT
40	AN960C10	WASHER

D3648-041 DRIVE SHAFT TUNNEL ASSEMBLY

RELEASED
08.03.27/10

NOTES:

- 1) SEAL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT EXCEPT WHERE NOTED
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3648-041 USING FINE POINT PERMANENT INK MARKER
- 7) TORQUE FASTENERS TO 15-25 in-lb
- 8) WEIGHT: 9.2 lbs

NO
HST
COPY
ATTN TO
FROM L.D. COPY
TO
WITHOUT
N. OFFICE

B	UPDATE WITH REVISED D3650-041	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3648	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	DRIVE SHAFT TUNNEL ASSY	1:6
DATE	08.01.07	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

7 6 5 4 3 2 1